

Work Order ID 107427

107427

Page 1

September-24-13 10:55:40 AM

Item ID: D3805-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate Ass'Y Fwd Low Gear
Start Date: 9/24/13 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 9/25/13 Req'd Qty: 2.00 ***2*** Customer: CU-DAR001
Reference: RMA RA111566 *RETURN*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3805	B

100

0.00

100

QC

Quality Control

Memo

INSPECT RA111566
2 X D3805-041 B92297

0.00

DAS
16
9-89

13/10/03

110

0.00

110

HandFinish

Hand Finishing

Memo

STRIP PARTS COMPLETELY

0.00

2 7/13/924

120

0.00

120

Large Fab

Large Fab

Memo

STEP 2 ON RS1012

0.00

2 13.9.25

Work Order ID 107427

107427

Page 2

September-24-13 10:55:40 AM

Item ID: D3805-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Wearplate Ass'Y Fwd Low Gear

Start Date: 9/24/13 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 9/25/13 Req'd Qty: 2.00 *2*

Customer: CU-DAR001

Reference: RMA RA111566

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				DAS 2 29 2-89	21	13-09-25	DAS 29 2-89 (DAS 09 2-89)
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				2		13-09-25	DAS 29 2-89 (DAS 09 2-89)
150 *150* QC Quality Control	SCA INSPECTION Memo	0.00 0.00				2		13-09-25	DAS 29 2-89

Work Order ID 107427

107427

Page 3

September-24-13 10:55:40 AM

Item ID: D3805-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearplate Ass'Y Fwd Low Gear
Start Date: 9/24/13 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 9/25/13 Req'd Qty: 2.00 ***2*** Customer: CU-DAR001
Reference: RMA RA111566

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
160									
Powdercoat	Memo	0.00							
Powder Coating	RE-POWDERCOAT ORANGE PER OSI005 4.0								
	START TIME: 2:30								
	OVEN TEMP: 320								
	FINISH TIME: 3:00								
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									

2x d m / 13/9/26

2x d m / 13/10/26

m12243

Work Order ID 107427

September-24-13 10:55:40 AM

107427

Page 4

Item ID:	D3805-041	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:					Stop	*NS2*
Item Name:	Wearplate Ass'Y Fwd Low Gear					
Start Date:	9/24/13	Start Qty:	2.00	*2*	Cust Item ID:	
Required Date:	9/25/13	Req'd Qty:	2.00	*2*	Customer:	CU-DAR001
Reference:	RMA RA111566					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		0.00							
180									
Small Fab	Memo	0.00							
Small Fab	INSTALL RUBBER GASKET PER DRG D3805 WITH 3M SCOTCH GRIP ADHESIVE								
	D3807-1 B <u>105189</u>								
	A/R 3M SCOTCH GRIP ADHESIVE								
	B <u>M 924297</u>								
190	QC5- Inspect part completeness to step on W/O	0.00							
190									
QC	Memo	0.00							
Quality Control									
200		0.00							
200									
Packaging	Memo	0.00							
Packaging									

DAS
27
9-89

B-9-27

2

2 8 13-10-03

Work Order ID 107427

107427

Page 5

September-24-13 10:55:40 AM

Item ID: D3805-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Wearplate Ass'Y Fwd Low Gear
Start Date: 9/24/13 Start Qty: 2.00 *2* Cust Item ID:
Required Date: 9/25/13 Req'd Qty: 2.00 *2* Customer: CU-DAR001
Reference: RMA RA111566

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210

0.00

210

QC

0.00

Quality Control

Memo

SCA INSPECTION, COMPLETE MAINTENANCE RELEASE ACCORDING
TO QSI 016

[Handwritten signature] / 11-3-10-3
MF
13-10-03

Picklist Print

September-24-13 10:56:23 AM

Page 1

Work Order ID: 107427

Parent Item: D3805-041

Parent Item Name: Wearplate Ass'Y Fwd Low Gear

Start Date: 9/24/13

Required Date: 9/25/13

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-07-21 new issue DD verified by:EC IPP Rev:B 09-03-04 rev.a as per dwg
DD verified by:EC IPP Rev:C 11.10.04 rev.b as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3805-041		Manufactured	No				Each	25.0000		2		9/23/09/27	
Wearplate Ass'Y Fwd Low Gear													

Location	Loc Qty	Loc Code
FP001	14	
91146	2	
91147	4	
93649	8	
FP002	11	
100050	5	
76779	1	
91144	2	
93648	2	
93651	1	

D3807-1

Gasket

Manufactured No

Each 14.0000

2

Location	Loc Qty	Loc Code
GA	14	
105189	14	



DART AEROSPACE LTD		Work Order:	102427
Description: Repair damaged training wearplate from FT. Rucker (AFT Batch:92298) (FWD Batch:92297)			D3805-041
Drawing: D3805		Repair Scheme:	RS1012
Part No: D3805-045 D3805-041		Page:	1 of 1
Batch No:		Qty:	2 ea.

Step	Location	Procedure	By	Date	Qty
1	Finishing	1- Remove all powdercoat from wearplate			
2	Large Fab	1- Inspect Wearplates for damage according to ICA D206-642 Rev. 5. 2- Install damaged wearplate on welding fixture 3- Re-weld area where weld is missing and repair cracks as per QSI 004 A/R S.S. Rod Batch: <u>None</u> 4- Re-form wear plate on welding fixture	cz	13.12.05	2
3	QC	QC9	DA 09	13-09-25	2
4	QC	QC5	DA 09	13-09-25	2
5	QC	SCA inspection	29	13-09-26	2
6	Powdercoat	Powdercoat Orange QSI 005 4.3 START TIME: <u>2:30</u> OVEN TEMPERATURE: <u>320 °F</u> FINISH TIME: <u>3:00</u> <u>M12243</u>		M. 13/09/26	2
7	QC	QC3	jd	13/09/26	2
8	Small Fab	Install rubber gasket as per dwg D3805 with 3M scotch grip adhesive D3807-5 Gasket Batch: <u>B105190</u> D3807-3 Gasket Batch: <u>B105189</u> A/R 3M scotch grip adhesive Batch: <u>M124297</u>	js	13/09/27	2
9	QC	QC5			
10	Packaging	Identify and stock			
11	QC	SCA inspection complete Maintenance Release according to QSI 016.	29	13 10 05	2

Rev	Date	Change Description	Prepared	Checked	Approved
-----	------	--------------------	----------	---------	----------

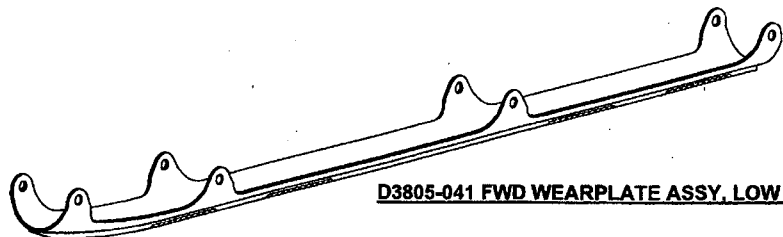
DART AEROSPACE LTD	Work Order:	107427
Description: Repair damaged training wearplate from FT. Rucker (AFT Batch:92298) (FWD Batch:92297)		
Drawing: D3805	Repair Scheme:	RS1012
Part No: D3805-045 D3805-043	Page:	2 of 1
Batch No:	Qty:	2 ea.

A	11.04.06	New Issue	DD		
---	----------	-----------	----	--	--

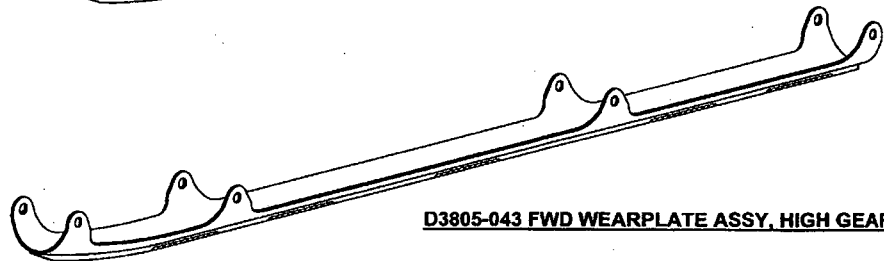
U:\Admin\Forms\Repairschemb\A.doc

Rev. A

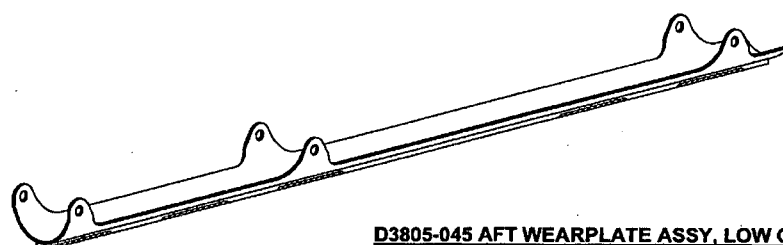
8 7 6 5 4



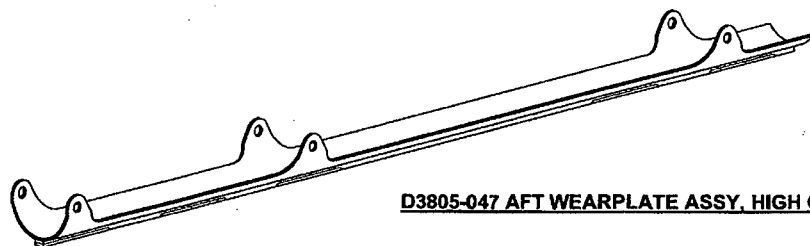
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



D3805-045 AFT WEARPLATE ASSY, LOW GEAR



D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

8 7 6 5 4

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

13-10-3
107427

RELEASED
2011-10-03
MD

B	REVISED D3805-1F/3F TO EASE MANUFACTURABILITY (ADDED CUTOOUT AT FWD END OF PLATE PER PART 11-108) AND RE-ORGANIZED NOTES SHEETS 2 & 3		MB	11.09.16
A	NEW ISSUE		MB	08.11.21
REV.	DESCRIPTION		BY	DATE
DESIGN	DART AEROSPACE USA, INC.			
DRAWN	KENT, WA			
CHECKED	DRAWING NO. D3805		REV. B	
MFG. APPR.	SHEET 1 OF 8			
APPROVED	TITLE WEARPLATE ASSY		SCALE NTS	
DE APPR.	DATE 11.09.16			

COPYRIGHT © 2008 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRELIMINARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

